Thursday, 7/19/2007 2:27:54 PM Date: Kim Johnston User: **Process Sheet** : PLATE : CU-DAR001 Dart Helicopters Services **Drawing Name** Customer Job Number : 33674 : 10425 **Estimate Number** : D32191 : WW Part Number P.O. Number S.O. No. : N/A · D3219 REV A **Drawing Number** : 7/19/2007 This Issue : N/A Project Number Prsht Rev. : SMALL /MED FAB ; A **Drawing Revision** First Issue : NIA 79 Um: : 33428 Material Previous Run Each : 7/31/2007 Due Date Written By Checked & Approved By New issue KJ/JLM : Est. Comment ESR B 06.05.25 Waterjet **Additional Product** Job Number: Description: **Machine Or Operation:** Seq. #: M6061T6S125 6061-T6 .125 Sheet 1.0 Comment: Qty.: Total : 2.0244 sf(s) 0.1012 sf(s)/Unit 6061-T6 .125 Sheet To be made in multiples of 4 Material: 6061-T6 (QQ-A-200/11) 0.125" thick (M6061T6S.125) Batch: M(02272 07/07/28 FLOW WATER JET WATER JET 2.0 Comment: FLOW WATER JET 1-Cut as per Dwg D3219 Dwg Rev: Prog Rev:\_ SAD 57/07/28 3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE 02101138 Comment: INSPECT PARTS AS THEY COME OFF MACHINE SECOND CHECK 4.0 QC8 Comment: SECOND CHECK SMALL & MEDIUM FAB RESOURCE 1 5.0 SMALL FAB 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Deburr if necessary.

Page 1

Form: rorocess

Dant Ae	ospace i	Liu						
W/O:			WC	RK ORDER CHANGES	3			
DATE STEP		PROCEDURE CHANGE			Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Categ	jory:		No DQA: 1		
						C Closed:	Date: _	
NCR:		•	WORK ORDE	ER NON-CONFORMAN	CE (NCR	)		
		Description of NC	Corrective Action Section B			Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description  Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
		·						

NOTE: Date & initial all entries

Date: User:

Thursday, 7/19/2007 2:27:54 PM

Kim Johnston

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLATE

Job Number: 33674

Part Number: D32191

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

QC21 8.0

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 07.572

## Dart Aerospace Ltd

W/O:		WORK ORDER	CHANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
Part No	:	PAR #: Fault Category:	NCR: Yes	No DC	A:	Date:	
			QA: N	/C Close	ed:	_ Date: _	
		WORK ORDER NON-COM	JEORMANCE (NCB	1			

		WORK ORDER NON-CONFORMANCE (NCR)								
Description of NC			Corrective Action Section E	Varification	Ammanal	A				
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspecto			
	STEP	STEP Description of NC Section A	STEP Section A Initial	STEP Section A Initial Action Description	STEP Section A Initial Action Description Sign &	STEP Section A Initial Action Description Sign & Section C	STEP Section A Initial Action Description Sign & Verification Approval			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	33674
Description: Plate	Part Number:	D3219-1
Inspection Dwg: D3219 Rev: A		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.316	+0.005/-0.000	£0.317			1212	
2.293	+/-0.005	2,198	<b>y</b>	,	Vern	
2.965	+/-0.010	2,970	0		Vern	
0.566	+/-0.010	6.569	<u></u>	/	vern	
0.375	+/-0.010	0.378	1	<u> </u>	Vern	!
R0.125	+/-0.010	R0.125	,		8-12	
0.125	+/-0.010	0.121	<i>J</i>		Vern	
13.9	+/-0.010	13.9			Protractor	
			·			
			*****			
					4-	

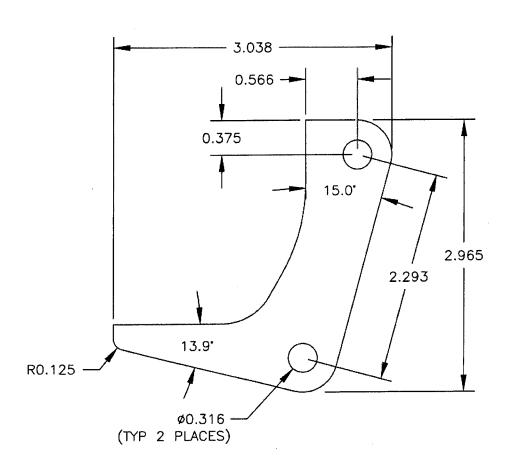
Measured by: SAD	Audited by:	Prototype Approval:	N/A
Date: 07/07/13	Date:	Date:	N/A

Rev	Date	Change	Revised by	Approv#d
Α	04.04.19	New Issue	KJ/JLM A	
	<u> </u>			





DESK	in A	DRAWN BY	DART AEROS HAWKESBURY, ONT	
CHEC	KED ,	APPROVED,	DRAWING NO.	REV. A
		1	D3219	SHEET 1 OF 1
DATE			TITLE	SCALE
03.	10.10		PLATE	1:1
Δ		03.10.10	NEW ISSUE	



## D3219-1 PLATE

- 1) MACHINE PER DWG FILE "D3219-1.SLDPRT"
- 2) MATERIAL: 6061-T6, 0.125 THICK (QQ-A-250/11) (REF DART SPEC M6061T6S.125)
- 3) FINISH: NONE
- BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE

Copyright © 2003 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.